

Work Order ID 128266

Tuesday, January 13, 2015 1:26:21 PM

128266

Page 1

Item ID: D3238-31 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Plate
 Start Date: 1/13/2015 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 1/20/2015 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 15-01-13 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3238	Rev C								

100 FLOW WATER JET 0.00
100
 Waterjet **(4)** DL 15/01/03
 FLOW CNC Waterjet
 6061.020" Memo 0.00
 1-Cut as per Dwg D3238
 Dwg Rev: C
 Prog Rev: C
 2-Deburr if necessary

Use cutting file D3238-21-23-25**

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00
 Quality Control **(4)** DL 15/01/03

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

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128266

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Item ID: D3238-31

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Plate

Stop

NS2

Start Date: 1/13/2015 Start Qty: 4.00

4

Cust Item ID:

Required Date: 1/20/2015 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00				(4)			DAS 38 9-89
120									
QC	Memo	0.00							
Quality Control									
130	Chemical Conversion Coat per QSI005 4.1	0.00				4	0	15-2-6	DGL JH
130									
HandFinish	Memo	0.00							
Hand Finishing									
140	QC7-Inspect Chemical Conversion Coat	0.00				(4)			DAS 38 9-89
140									
QC	Memo	0.00							
Quality Control									

FEB 03 2015

FEB 09 2015

DQA: _____ Date: _____



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Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>st 030</u>	0.00				<u>27</u>			
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

FEB 09 2015

MLJ 15-02-09

15.2-9

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

Tuesday, January 13, 2015 1:26:24 PM

Page 1

Work Order ID: 128266

128266

Parent Item: D3238-31

D3238-31

Parent Item Name: Plate

Start Date: 1/13/2015

Required Date: 1/20/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-01-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.020		Purchased	No			100	sf	39.5349	0.024	1			

M6061T6S 020

6061-T6 Sheet .020

**

DL 15/02/03

Location

Loc Qty

Loc Code

MAT020

12.5

M112442

12.5

MAT021

27.0349

119743

27.0349

1736

DQA: _____ Date: _____



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DART AEROSPACE LTD		Work Order:	128266
Description: Plate		Part Number:	D3238-31
Inspection Dwg: D3238 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.203	+0.005/-0.001	Ø .202	/		V-DC-02	
0.40	+/-0.030	.401	/			
0.33	+/-0.030	.331	/			
1.96	+/-0.030	1.963	/			
1.300	+/-0.010	1.302	/			
1.75	+/-0.030	1.750	/			
0.950	+/-0.010	.951	/			
0.80	+/-0.030	.80	/			
0.65	+/-0.030	.65	/			
0.650	+/-0.010	.651	/			

Measured by: DC Date: 15/02/03	DAS 38 FEB 09 2015	Prototype Approval: N/A Date: N/A	
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Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD	



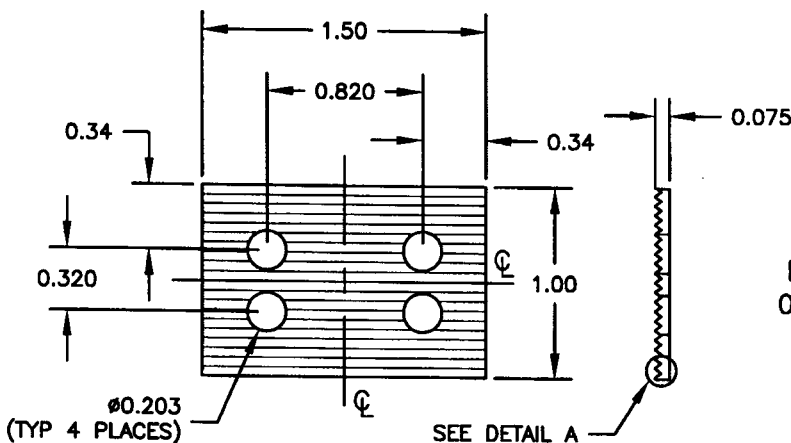
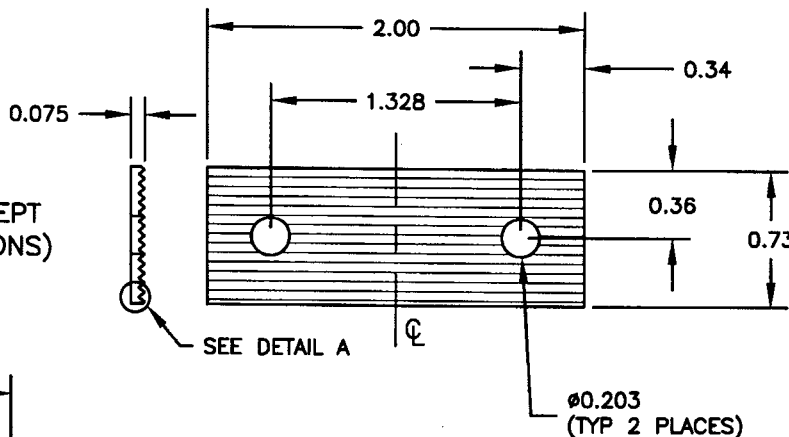
DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. C SHEET 1 OF 3
DATE 07.02.19		TITLE PLATE	SCALE 1:1
A	03.11.25	NEW ISSUE	
B	07.01.17	ADD -21/-23/-25/-31/-33/-35; CHANGE -11/-13/-15 TO 6061-T6	
C	07.02.19	ADD 5052-H32 OPTION	

RELEASED

07.02.20

D3238-1 PLATE (SHOWN)

D3238-11 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)



D3238-3 PLATE (SHOWN)

D3238-13 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

NOTES:

- 1) MATERIAL -1/-3/-5/-21/-23/-25 PLATE:
ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS 4037
(REF DART SPEC M2024T3S)
-11/-13/-15/-31/-33/-35 PLATE:
ALUMINUM 6061-T6/-T62 SHEET, 0.020 THICK, PER QQ-A-250/11 OR
AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.020)
OR
ALUMINUM 5052-H32 SHEET, 0.020 THICK, PER QQ-A-250/8 OR
AMS 4016 (REF DART SPEC M5052H32S.020)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) SEE SHEET 3 FOR DETAIL A
- 7) PARTS ARE SYMMETRIC ABOUT ϕ

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SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

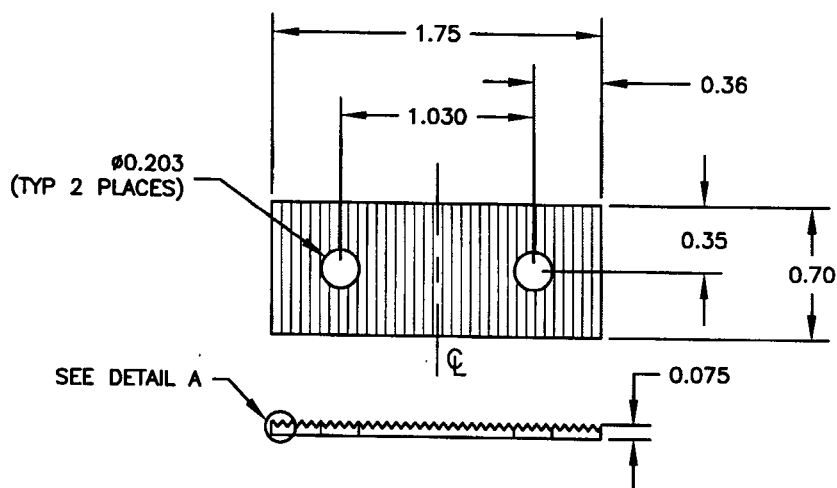
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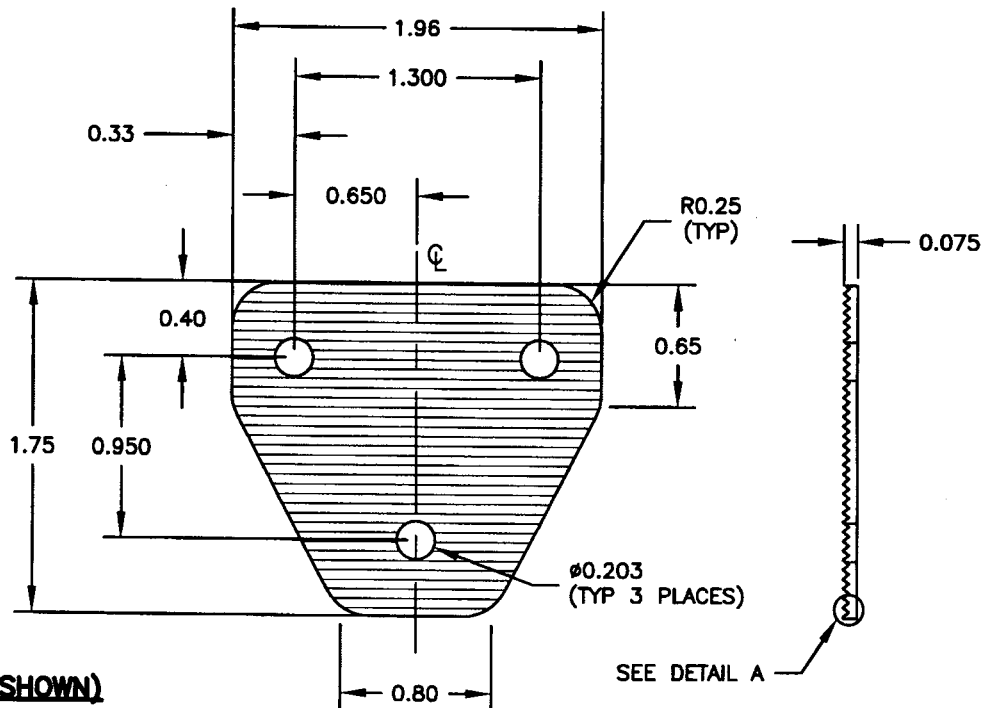


DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. C SHEET 2 OF 3
DATE 07.02.19		TITLE PLATE	SCALE 1:1



RELEASED
07.02.20

D3238-5 PLATE (SHOWN)
D3238-15 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)



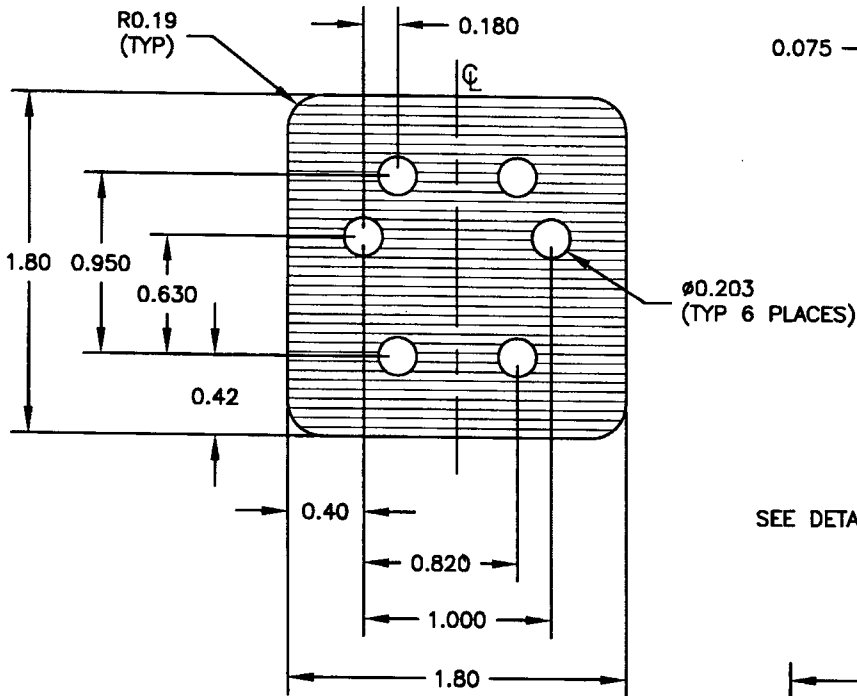
D3238-21 PLATE (SHOWN)
D3238-31 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

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DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. C SHEET 3 OF 3
DATE 07.02.19	TITLE PLATE		SCALE 1:1

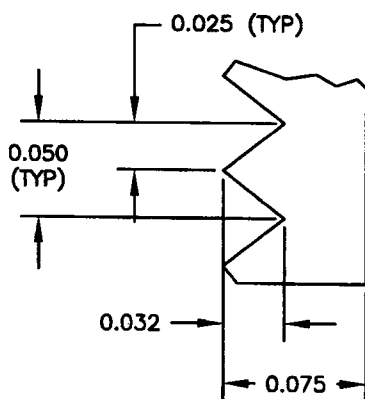


RELEASED

07.02.20

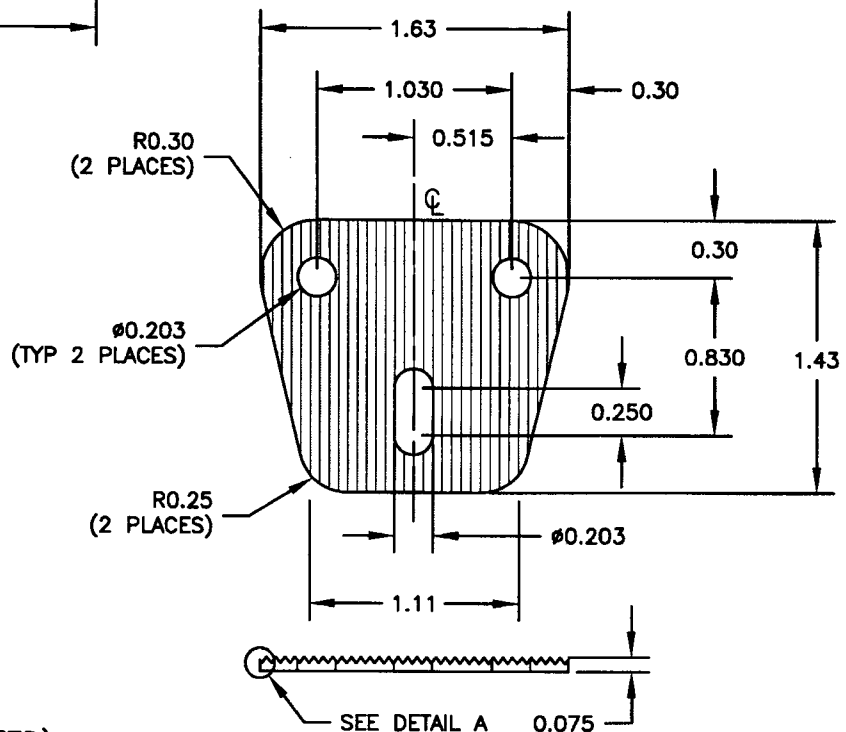
D3238-23 PLATE (SHOWN)
 D3238-33 PLATE (SAME, EXCEPT
 0.020 THICK AND NO SERRATIONS)

SEE DETAIL A



DETAIL A

RIDGE DETAIL (VIEW MAY BE ROTATED)
 SCALE 10:1



D3238-25 PLATE (SHOWN)

D3238-35 PLATE (SAME, EXCEPT
 0.020 THICK AND NO SERRATIONS)

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